

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013809**Date Inspected:** 05-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

Segment 7DW to 7EW (U-Ribs)

This QA Inspector performed dimension Inspection along with Caltrans QA Mr. Manikandan for the U-Ribs to U-Ribs (Total 39 nos.) for Segment 7DW to 7EW (Shop Segment Splice) between Panel Point (PP) 58 and PP 59 from Counter Weight side towards Cross Beam side. The measured readings were submitted to the Task Leader and Engineer for review.

Segment 7CW to 7DW (Transverse Splice)

This QA Inspector performed Dimension Inspection along with Caltrans QA Inspector Mr. Manikandan for the Horizontal Offset and Vertical Offset for the Transverse Segment T-Ribs to T-Ribs dimension was recorded from following work point for Segment 7CW to 7DW (Shop Segment Splice) between Panel Point (PP) 55 and PP 56 at the following locations

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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Side Panel from work point W6 to W4.

Bottom Panel from work point W4 to W3.

Side Panel from work point W3 to W1.

The measured and recorded readings were submitted to the Lead and Engineer for review.

Segment 8CE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress. The Weld joint is designated as SSD27-PP069-021. The welder is identified as 222396 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

CB8

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress. The Weld joint is designated as SP202A-008-016. The welder is identified as 220069 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-TC-U4b-F. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 7BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress. The Weld joint is designated as SSD12A-PP052-118. The welder is identified as 067571 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 7DW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress. The Weld joint is designated as CA041-005. The welder is identified as 067610 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Segment 7CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress. The Weld joint is designated as OBW7N-007. The welder is identified as 067663 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1. It was observed that the parameters noted down by ZPMC QC are in compliance with WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric T Sang 1500-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Math,Manjunath
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Carreon,Albert
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QA Reviewer
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